Work O	rder ID 111482
January-15-1	14 1:11:34 PM
Item ID:	D3584-1
Revision ID:	:
Item Name:	Web

111/00

Page 1

January-15-14	1:11:34 PM			· · · · · · · · · · · · · · · · · · ·	40/						1 agc	1
Item ID: Revision ID:	D3584-1			Accept	*N900	040	100)* s	etup Start	*N	S1*	
Item Name:	Web								Stop	*N	S2*	
		Qty: 4.00	*4*	A. T. T.	Cust Item II	D: 🔌	•					
Required Date:	1/31/14 Req'd	Qty: 4.00	*4*	•	Customer:		•	•				
Reference:							_	_	G 4 4			
Approvals:	Process Plan:	L)	Date: 1-01-1(Tooling:	Da	te:		R	un Start	*N	R1*	
	QC:		Date:	• SPC (Y/N):	Da	te:	•		Stop	*N	R2*	
Sequence ID/ Work Center II	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nb	r										_
D3584	Rev A				_							
100	Q1.1. 1			0.00			,			4.		
100	Skidtube	5				\wedge		1	4	₹ <u>`</u>		
Skidtubes Skidtubes		2-Drill Pillot H	as per Dwg D3584 foles using DT8960 Drill to 1.000" as per Dwg D3	Jig 584	14-8-19	\mathcal{J}	4/		·	*		
110	QC5- Ins	pect part complete	ness to step on W/O	0.00		~1	9					
110						V	See (145	2-19	7	
QC		Memo		0.00			•	LT T	17-6			
Quality Control						٠.				·ie		
120	Chamiaal	Conversion Coat	OSIO05 4 1	0.00						\triangle	7	
*120	Chemical	Conversion Coat	per Q31003 4.1	0.00				14-8	7-27	///	/ ,	
HandFinish Hand Finishing		Memo		0.00				<i>1</i> - C				

DQA:			Date:			DART									
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									
						DISPOSITION			<u> </u>						
Work Orde	er: _					_ ,	,		a	_	1		٦		
Part No.						Rework Scrap Use-as-is		ì	Skid-tube Crosstube Machining Small Fab noforming Finishing		4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR No.						Suspected Unapproved		mem	Large Fab Composite	_]				
Root					Desci	ription of work order update	ı	nitial	Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design															
Doc/Data	Н						İ					:			
Equip/Tooling	Н														
Handling/Pre	\vdash			ł											
Material	Н														
Operator	Н														
Offset/Setup	$\vdash\vdash$					·			,						
Process	Н						,				:				
Supplier Training	H										1				
Transport	H														
Unapproved	Н														
Oliappioved			L		L		FAI	ULT CA	TEGORY		<u>.J.,, </u>				
Landi	ng G	iear				General		<u> </u>				•			
Laria	$\overline{}$	Bending			<i>;</i>	1] Folio/F	Program	Γ	Outside Dim	ensions [Pressure/Forced		
	_	Centre No	ot Concei	ntric	'	Bend BOM/Route		Grain		_	Over/Under	[-	Set-up		
	Cracks					Broken/Damage/Defect		Hardwa	are	T	Part Incorred	-	Temperature/Cure		
	Crimp/Kink/Ripple/Wave					Burrs		4	ion Incomplete/Unqualified	Г	Part Lost/Mi	ssing	Weld		
	Cuffs					Contamination	-	4 '	tions Incomplete/Unclear	Г	Part Moved	Ť	Wrong Stock Pulled		
	Crushing					Countersink		_	gned/off center	\vdash	Positioned V	ے Vrong			
	-	Heat Trea				Cut Too Short	\vdash	Mislab	-		Power Loss/		Other		
	-	Inspectio		Tube		Drawing		Misrea			_				
	-	Marks/Ch	•			Drill Holes		Off-set				1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -			
		Turning S				Finish		-	Calibration						
	Wave/Twist in Tube					Fit/Function		Out of							

Work Order ID 1114

Work Order I ll January-15-14 1:11:.	•		*111		Page 2			
Item ID: D358 Revision ID: Item Name: Web Start Date: 1/15/		* / *	Accept	*N9000	4010	N *	Setup Sta	
Required Date: 1/31/ Reference:	•	*4*		Cust Item ID: Customer:				
Approvals: Pro	cess Plan:	Date:	Tooling:	Date:]	Run Sta	^IVIH I ^
QC		Date:	SPC (Y/N):	Date:			Sto	*NR2*
Sequence ID/ Work Center ID 130 *120* QC Quality Control 140 *120* Packaging Packaging	Operation Description QC7-Inspect Chemical Co Memo Identify as per dwg & Sto	16	Set Up/ Run Hours 0.00 0.00	Tool ID To	Cool # Plan Code	Accept Qty 4	Reject Qty	Reject Insp. Number Stamp
150 QC Quality Control	QC21- Final Inspection - ' Memo	Work Order Release	0.00			_Mc:	<u> п</u>	12-80-1

DQA:			Date:			- ``aart									
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:							<u>V</u>	/ork Order up	odate only			
Work Orde	/ork Order: DISPOSITION							AGAINST DEPARTMENT/PROCESS							
	٠			*****	_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering		
Part No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR No.				Suspected Unapproved			Large Fab	Composite		Supplier					
						,				·					
Root			1 1 1			ription of work order update	ı	nitial		tion	Sign &	_			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector		
Design										.*					
Doc/Data		•													
Equip/Tooling											•				
Handling/Pre															
Material	H											!			
Operator	_	ļ													
Offset/Setup Process	\vdash		ļ				l								
Supplier	-		İ			•									
Training												٠.			
Transport		1		,											
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							FA	ULT CA	TEGORY						
Landi	ng (Gear				General				_	_		_		
		Bending				Bend	*	Folio/F	Program	<u>.</u>	Outside Dim	ensions	Pressure/Forced		
		Centre Not Concentric				BOM/Route	L	Grain		-,	Over/Under	_	_Set-up		
		Cracks				Broken/Damage/Defect		Hardwa			Part Incorre	-	Temperature/Cure		
į		Crimp/Ki	nk/Ripple	/Wave	<u> </u>	Burrs		4	ion Incomplete/U	_	Part Lost/M	issing	Weld		
		Cuffs				Contamination	_	4	tions Incomplete/	Unclear	Part Moved	<u>L</u>	Wrong Stock Pulled		
		Crushing			<u> </u>	Countersink		4 '	gned/off center	ļ-	Positioned V		المال		
	<u> </u>	Heat Trea			<u> </u>	Cut Too Short	-	Mislabe	•	L	Power Loss/	Surge	Other		
	<u> </u>	Inspectio		Tube	<u> </u>	Drawing	_	Misrea							
	⊢	Marks/Cl				Drill Holes	\vdash	Off-set							
]	\vdash	4	Sequence		<u> </u>	Finish Fit/Function	-	-	Calibration'						
L	Wave/Twist in Tube					Trick-unction		Out of Sequence							

Picklist Print

January-15-14 1:11:34 PM

Page 1

Work Order ID:

111482

Parent Item:

D3584-1

Parent Item Name:

Web

Start Date: 1/15/14

Required Date: 1/31/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 07.06.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125		Manufactured	No			110	Each	46.0000	1	4			

105 I Beam Extrusion

Loc Oty Loc Code 46

46

DQA:			Date:			WORK ORDER MON	DART							
QA Closed:			Date:			WORK ORDER NON-	R NON-CONFORMANCE / UPDATE Work Order update only							
Mark Orden						DISPOSITION								
Work Order:						Rework	ı		Skid-tube Crosstube		1	Water Jet	Engineering	
Part No.						Scrap Use-as-is	1	Machining Small Fak		1	d. Eng. Coor. re/Packaging	Quality Other		
NCR No.						Suspected Unapproved	I					Supplier		
Root					Desci	ription of work order update	Ī	Initial	Action		Sign &			
Cause	}	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Design														
Doc/Data											1			
Equip/Tooling														
Handling/Pre												Ì		
Material														
Operator			ł				1							
Offset/Setup	П													
Process			1				İ							
Supplier			1											
Training	П		ŀ	·										
Transport														
Unapproved	П										<u></u>			
							FA	ULT CA	TEGORY					
Landi	ng G	ear	,			General		_			- 1		_	
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		Centre N	ot Conce	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect	š	Hardwa	are		Part Incorre	ci 👢	Temperature/Cure	
		Crimp/Ki	nk/Ripple	e/Wave		Burrs		Inspect	tion Incomplete/Unqualified	L	Part Lost/Mi	issing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled	
		Crushing				Countersink		Misali	gned/off center		Positioned V	Wrong	-	
	\Box	Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	'Surge	Other	
	\Box	Inspectio	n Strip in	Tube		Drawing	Γ	Misrea	d					
	П	Marks/Cl	hatter			Drill Holes		Off-set						
		Turning S	Sequence	!		Finish		Out of	Calibration					
	Wave/Twist in Tube					Fit/Function		Out of	Sequence					

D 56.00 5.59 (REF) 8.00 PITCH 7 EQUAL SPACES - 23.42 -- 15.10 ·--- 9.65 4.80 C 3.95 Ø1.00 (13 PLACES)

D3584-1 WEB

Α NEW ISSUE 07.06.08 REV. DESCRIPTION BY DATE DART AEROSPACE USA, INC.
PORT HADLOCK, WA DESIGN DRAWN DRAWING NO. CHECKED REV. A D3584 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE WEB DE APPR. 1:8 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.

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NOTES: 1) MATERIAL:MAKE FROM D2963-125 EXTRUSION 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.010 TO 0.020 6) IDENTIFICATION: N/A 7) WEIGHT: 5.08 lbs

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